

ABSTRACT OF THE DISCLOSURE

5 (insert) A body implantable medical device (IMD) includes a first shell and a second shell. The outer surfaces of the first and second shells are fabricated from a material compatible with body fluids. The implantable medical device further includes a battery enclosure defined by a cover and all or a portion of the first shell of the IMD housing. The cover of the battery enclosure is disposed between the inner surfaces of the first and second shells. An electrochemical cell, such as a flat liquid electrolyte battery, is provided in the battery enclosure. Electronic circuitry, which may be supported on a flexible wiring substrate, is provided between the inner surface of the second shell and the cover of the battery enclosure. A hermetic seal is provided between the cover of the battery enclosure and all or the portion of the first shell. The hermetic seal is preferably a weld joint, such as a butt weld or a tumble weld joint. 15 The hermetic seal may also be established by a spanked weld joint between the cover and all or a portion of the first shell. The battery enclosure cover may include a coined edge and the hermetic seal is established by a weld joint between the coined edge of the cover and a peripheral edge along all or the portion of the first shell. 20